

Work Order ID 63546

Thursday, November 04, 2010 10:01:27 AM

Page 1

Item ID: D3275-1

Accept

Revision ID:

Item Name: Crossbolt Spacer

Start Date: 11/4/2010 Start Qty: 40.00

Required Date: 11/19/2010 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3275	Rev A1								

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per Folio FA469 and Dwg D3275

10-11-9

40

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-11-9

40

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 10/11/09

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

40 0 10/11/23

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/23
ME

10-11-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 04, 2010 10:01:32 AM

Page 1

Work Order ID: 63546

Parent Item: D3275-1

Parent Item Name: Crossbolt Spacer



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A 04.10.19 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No			100	f	85.9337	0.2666	11.22526			



ALUM TUBE .3125 x .058w



Handwritten signature 10.11.9

Location	Loc Qty	Loc Code
MAT	19.43368421	
14559	19.4336842	
MAT013	66.5	
115894	66.5	

Handwritten 10.6

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 63544
Description: Crossbolt Spacer		Part Number: D3275-1
Inspection Dwg: D3275	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+/-0.010	3.175	/		Verifier	all RQ-02
0.025 - 0.030	N/A	.025	/			
45°	+/-0.01°	45°	/			
Ø0.31	+0.010/-0.005	.313	/			
0.058	Max = 0.0605 Min = 0.0555	.056	/			

Measured by: [Signature]	Audited by: M.A	Prototype Approval: N/A
Date: 10-11-9	Date: 10/11/09	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.10.19	New Issue	KJ/JLM	
B	06.03.09	Dimension Ø0.197 was Ø0.201	KJ/JLM	
c	09.05.04	Ø0.197 dimension removed	KJ/DD	[Signature]

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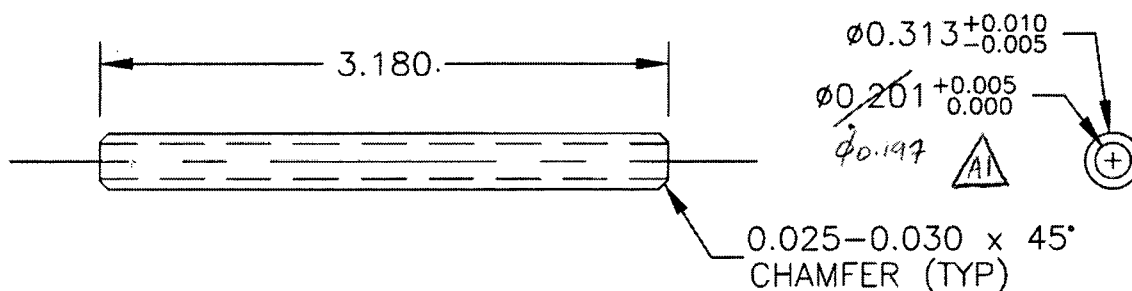


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3275	REV. A SHEET 1 OF 1
DATE 04.03.10		TITLE CROSS BOLT SPACER	SCALE 1:1
A	04.03.10	NEW ISSUE	
AI	<i>[Signature]</i> 04.10.19	CHANGE MAT'L SPEC	

RELEASED
04.06.22 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63544

2/10-11-04



D3275-1 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6R) M6061T6T0.313W.058 AI
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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